

Date: Friday, 03/04/2009 10:19:31 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : VERTICAL TUNNEL LOWER
Job Number : 46915	
Estimate Number : 13603	
P.O. Number :	Part Number : D38227
This Issue : 03/04/2009 S.O. No. :	Drawing Number : D3822 PRELIMINARY
Prsht Rev. : NC	Project Number : IN0002
First Issue : / / Type : THERMOFORMING	Drawing Revision : B PRELIMINAY
Previous Run : 44461	Material : MKYD6185S080P362015
Written By :	Due Date : 10/04/2009 Qty: 2 Um: Each
Checked & Approved By : <u>DD 09.04.03</u>	
Comment : Est. Rev. A New Issue 08.09.25 DL Rev B Dwg. Update. 09/02/09 DL verified by:DD	

Additional Product

PRELIMINARY ISSUE



Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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Comment: Qty.: 5.4170 sf(s)/Unit Total : 10.8340 sf(s)
 6185 Kydex .080"

M109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/04/06

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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**Comment:** HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/04/06 (X2)

4.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-7 and folio FTA 029) using tool DT 9396

Dwg. Rev. BFolio Rev. B

BB 09/04/06 (X2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 03/04/2009 10:19:32 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL LOWER

Job Number: 46915

Part Number: D38227

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

BB 09/04/06 (x2)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

690415

BB 09/04/06 (x2)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/07 (x2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/07 (x2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

✓ checked by S.M.

690415 (2)

PTC

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: _____

POSITIVE RECALL

EFFECTIVE 09.04.03 AUTH 1
RELEASED 14 DATE 09.04.14

09/4/15 (2)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



09.04.15

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3822-7 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/15
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46915</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-04-15	9.0	Upon inspection it was noticed that the parts are warped from top to bottom, 0.050 → 0.100. This is caused from the mold & the mold being heated R.C. mold.	<u>ASIMU2</u>	Eng to issue a project number to re-work existing molds to eliminate deformation. Reel tray mold per modification. Acceptable to Eng	<u>BB</u> 09/04/15	<u>654-15</u>	<u>09/04/15</u>	<u>654-15</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46915
Description:	Part Number: D 3822-7
Inspection Dwg: D3822 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/04/07

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
5.9		5.925	✓			
17.00	Min	17.625	✓			
2.0		2.0	✓			
.20 / .15		.1485	✓			
.040		.063	✓			

Measured by: BB

Date: 09/04/07

Audited by:

Date: 09/04/07

Prototype Approval:

Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



